

RUTOX-E

CODIFICATION:

AWS	:	SFA 5.4	E317L-16				
IS	:	5206	E19.12.3LR16				

CHARACTERISTICS AND APPLICATIONS:

Rutox-E is a stainless steel electrode depositing an extra low carbon weld metal containing 18Cr-12Ni-3Mo. It is ideally suited for welding stainless steels of similar composition and AISI316L varieties and their equivalents. The extra low carbon content ensures excellent corrosion resistance against sulphuric acids, phosphoric acids, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	Cr	Ni	Mo	S	P
Percent	:	0.035	1.60	0.46	19.0	12.2	3.20	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L= 4d)%
604	36.0

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	150-180	110-140	80-100	60-80
(Amps)					
Weight/Cartron	:	2.5	2.5	2.5	2.5
(kgs)					

PRECAUTIONS:

1. The electrode should be dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour.
2. Use short arc length and stringer bead to reduce heat input.